

Date: Wednesday, 3/14/2007 12:25:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 31198	
Estimate Number : 12464	
P.O. Number : <i>NA</i>	Part Number : D35087
This Issue : 3/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3508 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28970	Material : <i>N/A</i>
Written By : <u><i>[Signature]</i></u>	Due Date : 3/30/2007 Qty: 8 Um: Each
Checked & Approved By : <u><i>[Signature]</i></u>	
Comment : Est Rev:A New Issue 06-06-20 JLM	
Est Rev:B Now SS as per Rev B 06-12-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.3272 sf(s)/Unit Total : 2.6174 sf(s)
 304 SS .038" THK
 (M304S20GA)
 Batch: *M101 463*

SAD 02/04/14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: *B*
 Prog Rev: *B*

2-Deburr if necessary

SAD 07/04/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 02/04/14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 07/04/14

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 07/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:47 PM
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Process Sheet

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Drawing Name: WEARPLATE

Job Number: 31198

Part Number: D35087

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-04-23 (8)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M 101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-04-26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8X)

Comment: INSPECT POWDER COAT

M-d

07/04/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP 18

M-d 07/04/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/30

Job Completion



U 07-04-30

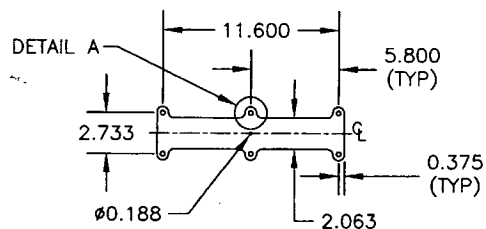
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

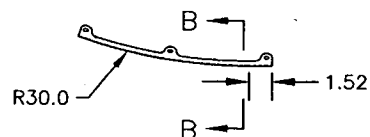
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

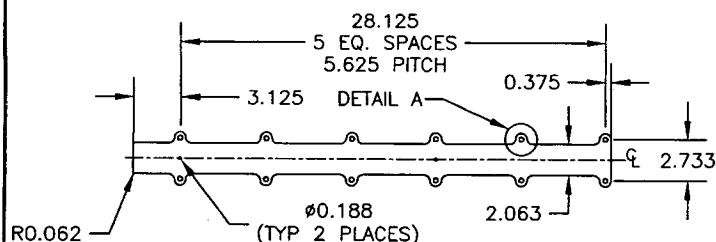
NOTE: Date & initial all entries



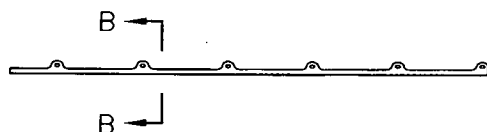
D3508-1 FLAT PATTERN



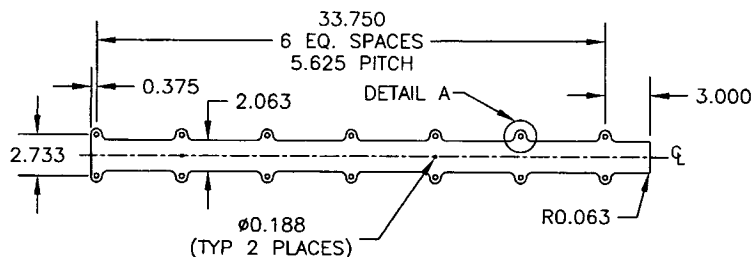
D3508-1 BENDING DETAIL



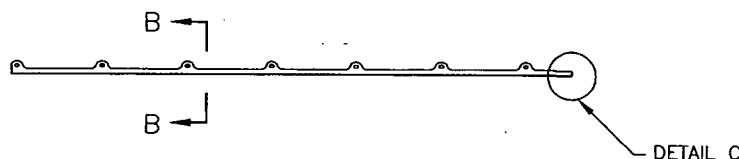
D3508-5 FLAT PATTERN



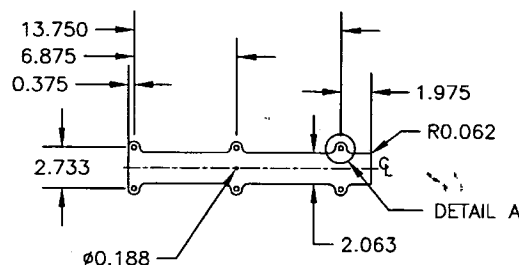
D3508-5 BENDING DETAIL



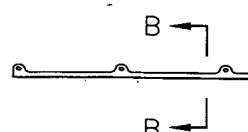
D3508-3 FLAT PATTERN



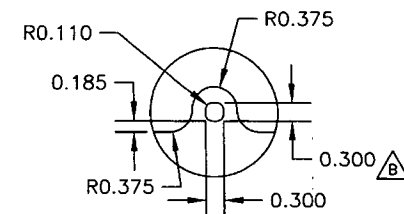
D3508-3 BENDING DETAIL



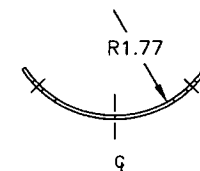
D3508-7 FLAT PATTERN



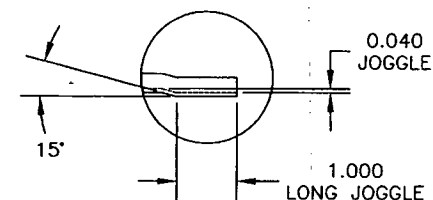
D3508-7 BENDING DETAIL



**DETAIL A
SCALE 1:2**



**SECTION B-B
SCALE 1:2**



**DETAIL C
SCALE 1:2**

D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED

06.12.12

NO. 31198
WORK ORDER
SUBJECT TO AN ENDMENT
WITHOUT NOTICE
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ENGINEERING
RETURN TO
SHOP COPY

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B	06.10.27	CHANGE STAINLESS STEEL, WIDEN TAB
A	06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.10.27	TITLE WEARPLATE
DRAWING NO. D3508		REV. B SHEET 1 OF 1 SCALE 1:8
DART AEROSPACE USA, INC. PORT HADLOCK, MA		

DART AEROSPACE LTD		Work Order: D35087
Description: Wear Plate		Part Number: 31198
Inspection Dwg: D3508 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 13.750	+/- 0.010	13.750	✓		Vern H-T	
B 6.875	+/- 0.010	6.875	✓		Vern/Mr	
C 0.375	+/- 0.010	0.380	✓		Vern	
D 2.733	+/- 0.010	2.733	✓		Vern	
E 2.063	+/- 0.010	2.069	✓		Vern	
F 1.975	+/- 0.010	1.980	✓		Vern	
G Ø0.188	+/- 0.005	Ø0.192	✓		Vern	
H 0.300	+/- 0.010	0.302	✓		Vern	
I 0.300	+/- 0.010	0.300	✓		Vern	
J 0.038	+/- 0.010	0.035	✓		Vern	
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: J.L.	Prototype Approval:	N/A
Date: 07/04/14	Date: 07/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	